

# Work Order ID 62832

Friday, October 08, 2010 12:49:35 PM



Page 1

Item ID: D3211-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 10/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*PK*

Date: 10-10-8

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3211	Rev A1 / DEO

100 0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3211 ☐ Dwg Rev: A1 ☐ Prog Rev: A1 ☐ 2-  
Deburr if necessary

2024 .063

10-10-13

*C*

110 0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

10-10-13

120 0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

10/10/13

*(+6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

[illegible]

Page 2

**Accept**

[illegible]**Setup Start**

**Stop**

(b) (7)(C), (b) (7)(D)

**Cust Item ID:**

1000

**Customer:**

**Reference:**

Run Start

**Stop**

**Insp.  
Stamp**

0.00

[illegible]

0.00

## Memo

Deburr

0.00

**Abstract**

0.00

## Memo

Bend D3211-1 Stack as per Dwg D3211

0.00

**Abstract**

QC5- Inspect part completeness to step on W/O

0.00

## Memo

## Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 62832

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Page 3

Item ID: D3211-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 10/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	BR 10-10-26			6			
170  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M 112 588 Memo START TIME: 11:30 320° FINISH TIME: 12:00	0.00 0.00				6		BR 10-10-27	
180  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	=> 10/10/27			6	0		

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 62832**

Friday, October 08, 2010 12:49:35 PM



Page 4

Item ID: D3211-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 10/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: *511*

0.00



Packaging

Memo

0.00

Packaging

*10/10/28 J (6)*

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/10/28 J**mf**10-10-28*

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**NOTE:** Date & initial all entries



# Picklist Print

Friday, October 08, 2010 12:49:40 PM

Page 1

Work Order ID: 62832



Parent Item: D3211-1



Parent Item Name: Bracket

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-17 JLM  
IPP Rev:B Now on Waterjet 06-10-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

100

sf

104.8000

1.405

8.873684

8.8



10-10-13

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT22

104.8

113866

15.5

114351

89.3

114351

6

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3211	REV. A SHEET 1 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3
A	03.09.03	NEW ISSUE	
AI	<i>[Signature]</i> 03.12.05	CHANGE ALL BEND RADII TO R0.125	

RELEASED  
03 09 15

DEO ATTACHED

ON  
C3367

NOV 19 1980

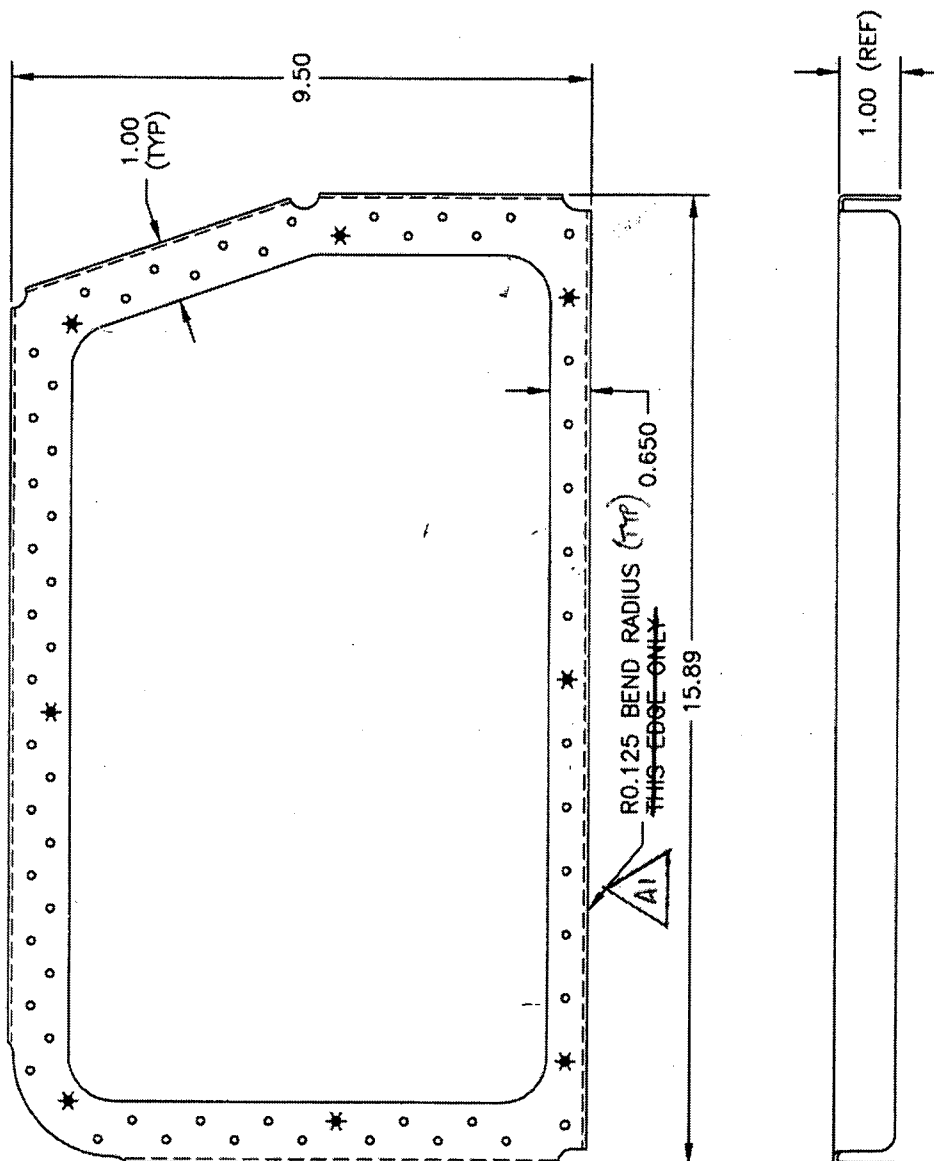
U.S. DEPARTMENT OF AGRICULTURE  
NATIONAL ARCHIVES

OFFICE OF THE DIRECTOR  
OF RECORDS MANAGEMENT

WASHINGTON, D.C.

ADDITIONAL INFORMATION

D3211-1 BRACKET  
MACHINE PER DRAWING FILE "D3211-A2.DWG"  
CHECK PER TEMPLATE D3211-1T1  
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063"  
FINISH: ACID ETCH AND ALODINE PER DART QSI  
POWDER COAT BLACK SANDTEX (4.3.5)  
USE MINIMUM BEND RADIUS OF ~~0.188"~~ EXCEPT  
TOLERANCES ARE PER DART QSI 018 UNLESS



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





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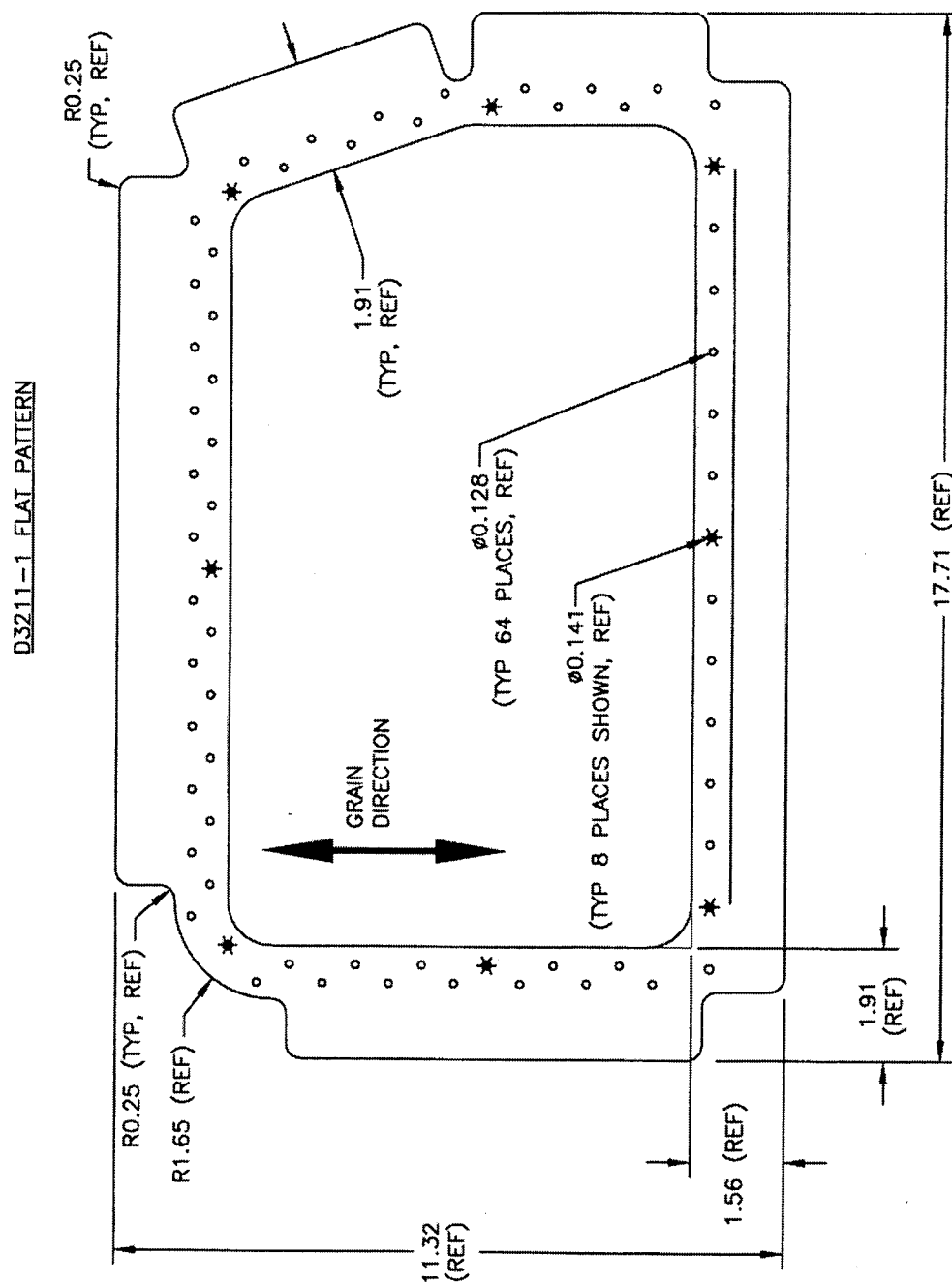
**NOTE:** Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3211	REV. A SHEET 2 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3

RELEASED  
03 09 15 4

**DEO ATTACHED**



u/b 62832

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**Dart Aerospace Ltd**

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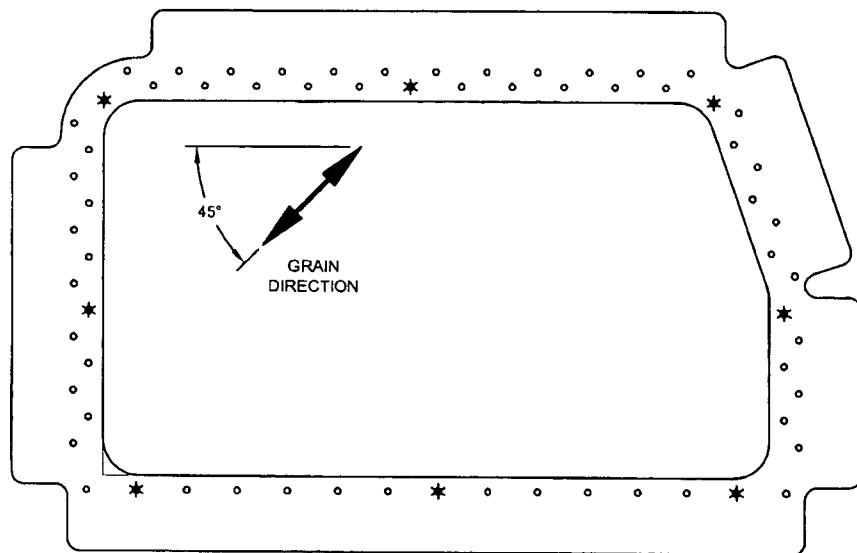
**NOTE:** Date & initial all entries



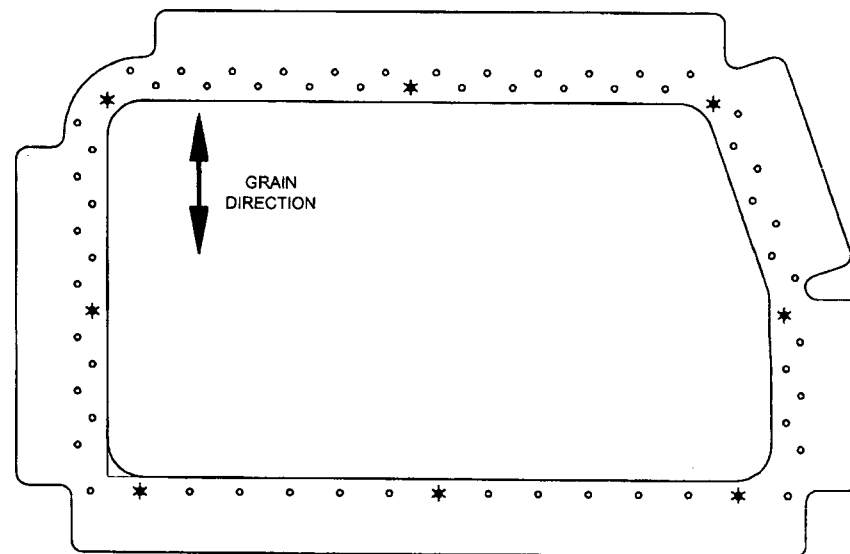
DRAWING NO. D3211	TITLE BRACKET	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3211-A-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.09.12	DATE 08.09.12	DATE 08.09.12	DATE 08.09.12		DATE 08.09.12		

SHEET 2 MODIFY GRAIN DIRECTION AS SHOWN BELOW TO FACILITATE BENDING (SEE CAR 08-001).

IS:



WAS:



**RELEASED**  
08.09.12

ALL OTHER INFORMATION REMAINS UNCHANGED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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